

731-011

Dart Aerospace Ltd.

Date: Wednesday, 22/04/2009 11:39:21 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MECHANICAL GROUND HANDLING WHEEL KIT	
Job Number :	47363B			
Estimate Number :	12140			
P.O. Number :		Part Number :	D206731042	
This Issue :	22/04/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	DSK 093 REV B	
First Issue :	//	Project Number :	N/A	
Previous Run :	47362B	Drawing Revision :	B	
		Material :		
Written By :		Due Date :	05/06/2009	Qty: 1 Um: Each
Checked & Approved By :	<u>010 09.04.22</u>			
Comment :	est rev. A 01.02.01 new issue EC Est Rev:B As per Rev b 07-02-13 JLM est rev C 07.05.14 rev C IIN ec			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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✓ 1.0	D33355	spring
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) pick:		

qty	Part Number	Description	batch
1	D3335-5	spring	B44058

SAD 09-05-14

✓ 2.0	D3353042	Lug Weldment
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) pick:		

qty	Part Number	Description	batch
1	D3353-042	LUG ARM WELDMENT	B47616

SAD 09-05-14

✓ 3.0	D3354042	Mirror Arm Weldment
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) pick:		

qty	Part Number	Description	batch
1	D3354-042	Left Arm Weldment	B40160

SAD 09-05-14

✓ 4.0	D3354043	Right Arm Weldment
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) RIGHT ARM WELDMENT		

batch:	B36639
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SAD 09-05-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33561

Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3356-1	pin	B94575

SAD 09-06-14

6.0

D3397041

Wheel Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	D3397-041	Wheel ass'y	47618-1

SAD 09-06-14

7.0

113800

GREASE FITTING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	113-800	GREASE FITTING	2109654

SAD 09-06-14

8.0

656051

flat washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	656-051	flat washer	2105735

SAD 09-06-14

9.0

663079

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	663-079	Lock washer	16362

SAD 09-06-14

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Description :

10.0

AN523A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	AN5-23A	Bolt	M19278

SAD 09-05-14

11.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	AN960JD516	Washer	M110523

SAD 09-05-14

12.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	CP-21	1/8" Cotter Pin 2" long	M108200

SAD 09-05-14

13.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	MS21042L5	Nut	M109840

SAD 09-05-14

14.0

SNF34

SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	SNF-34	SLOTTED NUT	M102295 (1)

~~M111550 (1)~~ SAD 09-05-14
↑
Gone to Lala Land

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Machine Or Operation:

Description :

15.0

TP2

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	TP-2	Spring pin	M16588

batch
M16588

SAD 09-05-14

16.0

TP134

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

qty	Part Number	Description	batch
1	TP-134	Spring pin	M16362

batch
M16362

SAD 09-05-14

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per dwg DSK 093

2-Grease fitting 113-800, apply LPS C30316 on all parts areas not protected by paint or grease.

SAD 09-05-14 ⑦

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 09-05-14 ⑧

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPR47363

SAD 09-05-15 ⑨

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/14

Job Completion



MF 09-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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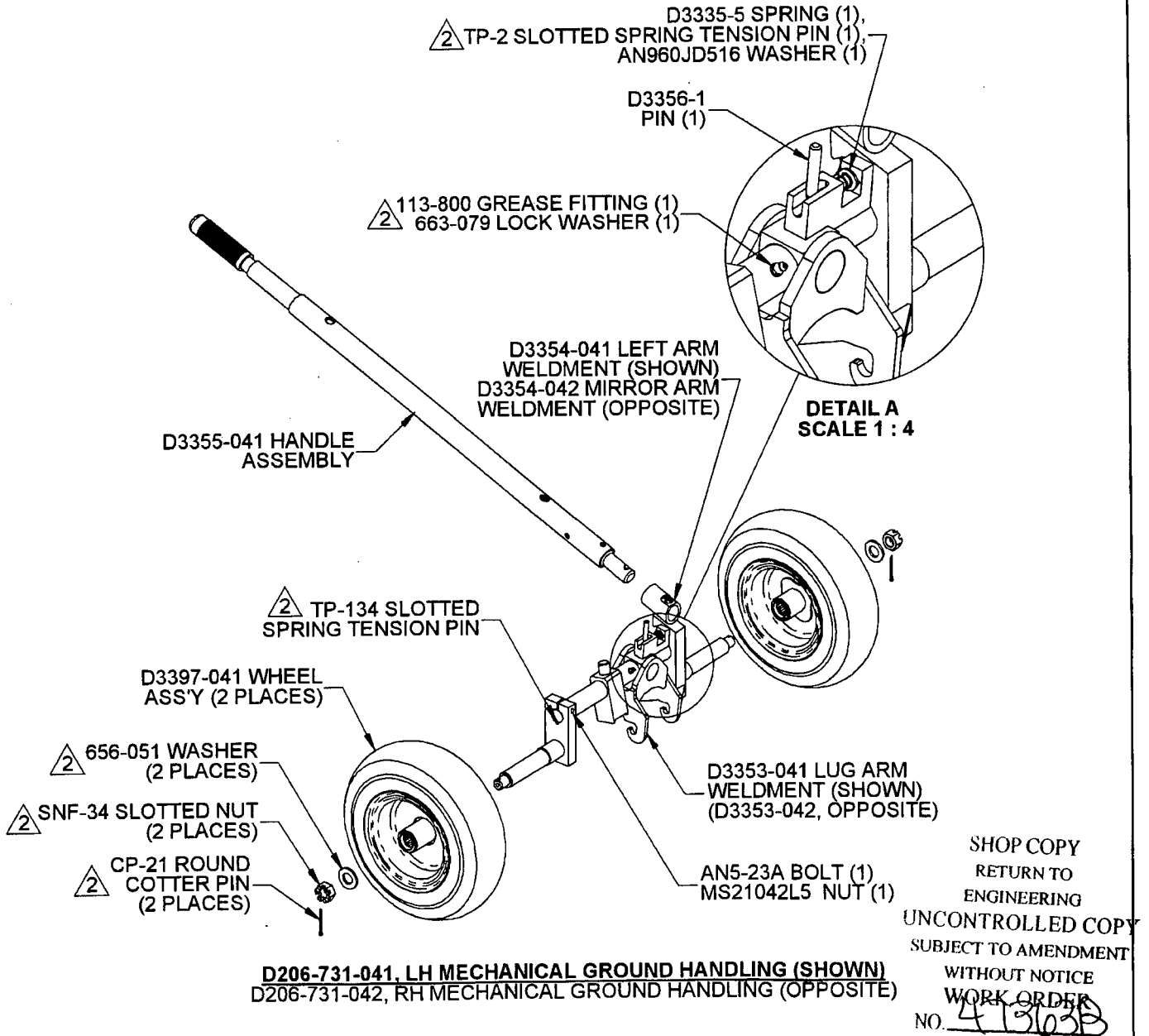
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DART**RELEASED**
07.02.05

DESIGN RF	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 093	REV. B SHEET 1 OF 1
DATE 07.02.02		TITLE MECH. GROUND HANDLING	SCALE 1:10
REV	DATE	DESCRIPTION	
A	05.02.10	NEW ISSUE	
B	07.02.02	REDRAWN	

**NOTE:**

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE.
RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.
- 2) SUPPLIER: SPAENAUER.

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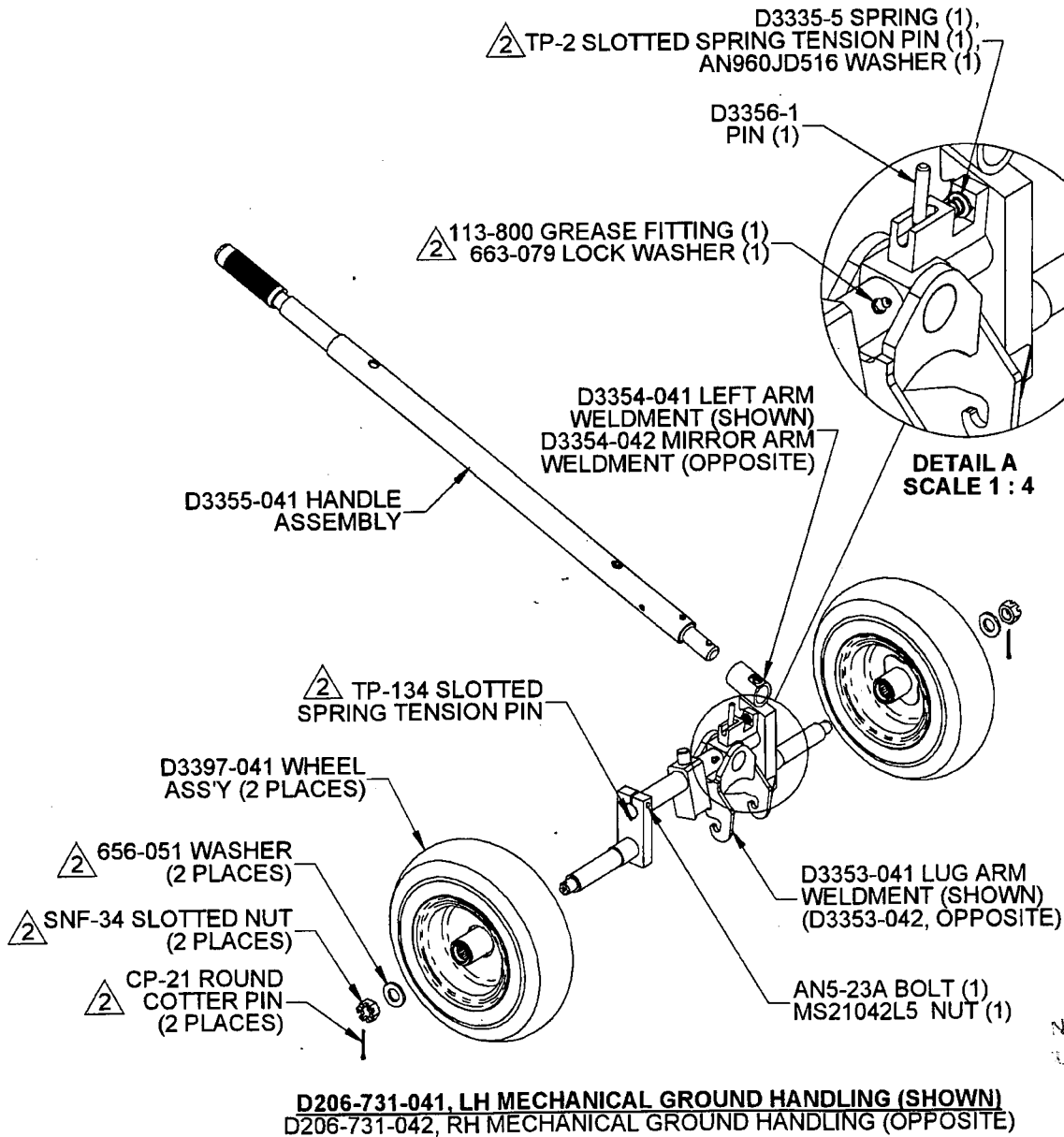
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07.02.05

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSK 093	REV. B SHEET 1 OF 1
DATE 07.02.02		TITLE MECH. GROUND HANDLING	SCALE 1:10
REV	DATE	DESCRIPTION	
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SHOP COPY
RETURN TO
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WORK ORDER
473028

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